Work Order 1 September-27-13 1:			*107		Page 1				•			
Revision ID:	461-7 unting Plate		Accept	*	<b>1900</b>	<b>040</b>	100	<b>)</b> * s	Setup Star Stop	14	S1* S2*	
Required Date: 9/2	7/13 Start Qty: 20.00 7/13 Req'd Qty: 20.00	*20* *20*			Cust Item I Customer:	D:						
	rocess Plan: MLゴ	Date: 13-09-7	Tooling: SPC (Y/N):			ate:		F	Run Star Stop	1/	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	<del></del>
Draw Nbr	Revision Nbr											
D3461	Rev A											
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET  Memo  1-Cut as per  Dwg Rev:  Prog Rev:	Dwg D3461	0.00	0				20	_0_		Ac 13.10	· 30
*110 *110*	2-Deburr if a QC2-Inspect parts off m		0.00					20			Ao	
QC Quality Control	Memo		0.00								13.12	۱·3u
*120	QC8- Inspect parts - seco	ond check	0.00					(Q)	) <i>1</i> 4-6	)1-03	DA 9	
QC	Memo		0.00		,					, <u> </u>	9-8	9

Quality Control .

											DQA:	Date:	
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UP	DATE			-
			•								QA Closed:	Date:	
Work Ord	lor:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	Part No.  NCR No.					Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other		
Root					Descri	ption of work order update	T	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material			į										
Setup													
Other	Г												
Process													
Supplier	Г												
Training													
Unapproved													
						F	AUI	T CATE	GORY				
Landi	ing (	Gear				General		_			_		
1		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ect	Weld
Crushed/Crimped. Burrs						Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/M	lissing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte			Part Moved	<u> </u>	·
		Heat Trea	ıt			Countersink	Г	Mislabe	led		Positioned Wrong		
	Inspection Strip in Tube					Cut Too Short	<b>⊢</b>					/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Work O	rder	ID	107696
Cantambar 2	7 12	1.10.1	1 DM

Packaging

Page 2 Accept Item ID: D3461-7 \*N900040100\* Setup Start **Revision ID:** Mounting Plate Item Name: Start Qty: 20.00 9/27/13 **Start Date: Cust Item ID:** Required Date: 9/27/13 Req'd Qty: 20.00 **Customer:** Reference: Run Start Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Reject Operation Set Up/ Tool ID Tool# Plan Accept Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** 130 0.00 Small Fab \*130\* Small Fab 0.00 Memo Small Fab Deburr parts per dwg D3461 DAS 9 9-89 140 QC5- Inspect part completeness to step on W/O 0.00 \*140\* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 100 0.00 150 \*150\* Packaging 0.00 Memo

\*\*\* STOCK IN STEP CELL\*\*\*

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	CON	VFOR	MANCE / UPD				
											QA Closed:	Date:	
Work Ord	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	er. <b>–</b>					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-		•			Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No					Work Order Update	]		Large Fab	Composite		Supplier	
					T				<u> </u>			-	<u> </u>
Root		_	_		i	ption of work order update	1	nitial	Actio		Sign &		
Cause	_	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data	Н					•						,	
Equip/Tooling	Н												
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш												
Process	Ш												
Supplier	Ш												
Training	Ш											Ì	
Unapproved													
						F.	AUL	T CATE	GORY				
Landi	ing G	ear			_	General	_	,			•	<b></b>	7
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
					BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure	
}	$\bigsqcup$	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
Crushed/Crimped. Burrs					Burrs		Instruct	tions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled	
Cuffs Contamination					Contamination	Maintenance Part Moved							
					Countersink		Mislabeled			Positioned \	<b>V</b> rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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<b>Work Ord</b> September-27-1				*107			Page				
Item ID: Revision ID: Item Name:	D3461-7  Mounting Pla	ate		Accept	*N900	<b>040</b>	100	)* Setup S		1 (1)	S1* S2*
Start Date: Required Date Reference:	9/27/13 e: 9/27/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					
QC:		an:	Date:	Tooling: SPC (Y/N):	Date: Date:			R	un Start Stop	1/1	R1* R2*
Sequence ID/ Work Center 1 160 *160* QC QC Quality Control	ID	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty  Od60	Reject Number	Insp. Stamp

												DQA:	Da	te:	
NCR:	⁄es	/ No				WORK ORDER NON-O	O	NFORI	MANCE / UP	DATE		•			
												QA Closed:	Da	te:	
Work Orde						DISPOSITION				AGAINST D	ÞΕ	PARTMENT	PROCESS		
WOIK OIG	-				<del></del>	Rework	וו		Skid-tube	Crosstube	$\neg$	1	Water Jet	$\Box$	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	$\dashv$	Pro	d. Eng. Coor.	-	Quality
1 4761	<b>1</b> 0.					Use-as-is	1		noforming	Finishing	$\dashv$		e/Packaging	-	Other
NCR I	No.					Work Order Update	1	1.1.0111	Large Fab	Composite	ᅱ	1100,0101	Supplier	-	
						' -	<b>.</b>		° Ш			<u>.</u>	•••		<b>L</b>
Root					Descri	ption of work order update		Initial	Act	tion	$\Box$	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling											1				
Operator											ŀ				
Material															
Setup															
Other															
Process															
Supplier						•									
Training															
Unapproved			<u> </u>												
							AUL	LT CATE	GORY						
Landi						General		7		_		7			1
	-	Bending			<u> </u>	Bend		Grain				Ovalized		<u>_</u>	Pressure/Forced
	Щ	Centre No	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa		Ļ	_	Over/Under		<u></u>	Temperature/Cure
	$\vdash$	Cracks			L	Broken/Damaged		Inspect	ion Incomplete	1		Part Incorre	ct	<u></u>	Weld
		Crushed/	Crimped.		[	Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	issing	1	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

September-27-13 1:10:14 PM

Work Order ID:

107696

Parent Item:

D3461-7

Parent Item Name:

Mounting Plate

**Start Date:** 9/27/13

Required Date: 9/27/13

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP REV. A 05.12.13 NEW ISSUE

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.000 6061-T6 Bar .187 x 4.00		Purchased	No			100	f	86.4900	0.042	0.88421	A	2 13.	10.30
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT051		86.49							
				1232	79	22.84							

63.65

125590

125590 → #.s. 28

				DQA:	Date:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE	<del></del>	

	,									QA Closed:	Date	e:
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT/	/PROCESS	
Work Orac					Rework	7 <b> </b>	Skid-	tube	Crosstube		Water Jet	Engineering
Part N	No.				Scrap	┨	Machi	<del></del>	Small Fab	Pro	d. Eng. Coor.	Quality
	···	· · · -		<del></del>	Use-as-is	The	ermofori	~ —	Finishing		re/Packaging	Other
NCR I	No.				Work Order Update	1   ```	Large	~	Composite		Supplier	
			•							4	_	
Root				Descri	iption of work order update	Initia	l	A	ction	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief E	ng	Des	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material											ļ	
Setup												
Other		ļ	1									
Process												
Supplier				İ								
Training												
Unapproved		<u> </u>				<u> </u>			<u> </u>			
					F	<b>AULT CA</b>	TEGORY	,				
Landi	ng Gear				General					<b>-</b>	_	_
	Bendin	3			Bend	Grai	in			Ovalized	<u> </u>	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	_BOM/Route	Hard	lware			Over/Under	tolerance	Temperature/Cure
	Cracks			L	Broken/Damaged	Insp	ection Inc	complete		Part Incorre	ct	Weld
	Crushed/Crimped_ Burrs		Burrs	Instr	uctions I	ncomplete	e/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
			Contamination	Mai	ntenanc	e		Part Moved				
	Heat Treat Countersink			Countersink	Misl	abeled			Positioned V	Wrong _		
	Inspection Strip in Tube Cut Too Short			Misr	ead			Power Loss/	'Surge	Other		
	Ripples	in Bend			Drill Holes	Offs	et					
Torque Waves in Extrusion Drawing			Drawing	Out	of Calibra	ation						
	Turning Sequence Finish			Finish	Out	of Seque	nce					

Outside Dimensions

Wave/Twist in Tube

Folio

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DART AEROSPACE LTD	Work Order: 107 696
Description:	Part Number:
Inspection Dwg: Rev:	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.101	+1- ,010	1.101			٧	JKn-05
1.337	+1- 1010	337	_		V	
2.715	+1- ,010	2.715			V	
.586	41- 1010	.586			· · ·	
RO.125	+1- ,030	.125	_		V	
d.257	T4006/001	<i>-257</i>	<		V	
					i	

			DAS			
Measured by:	Ae	Audited by:	9 9.89	Prelimina	ry Approval:	
Date:	13 112.30	Date:	14-01-03		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15



